

Date: Monday, 26/03/2007 12:39:23 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HELI-ACCESS STEP LH (FOLDING)
<b>Job Number</b> : 31459	
<b>Estimate Number</b> : 12567	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D412630033
<b>This Issue</b> : 26/03/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : UNDER REVIEW to meet orders
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : K
<b>Previous Run</b> : 29384	<b>Material</b> : N/A
<b>Written By</b> : _____	<b>Due Date</b> : 02/04/2007 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : _____	
<b>Comment</b> : Est. Rev:A New Issue 06-11-08 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile &amp; create labels per PPP D412-630-033 CHG001

①  
 KS 07-03-28

2.0	D2012107	Clevis
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Clevis

Pick:

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	B27520

3.0	D2803041	Bracket Assembly
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2803-041	Bracket Assembly LH	B29391

4.0	D2804041	Bracket Assembly
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2804-041	Bracket Assembly LH	B27102 - MF 07-04-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 26/03/2007 12:39:24 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 31459

Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D2807	Support Prop
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Support Prop

Pick:

Qty	Part Number	Description	Batch
2	D2807	Gas Spring	B 28488

6.0	D2813	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Washer

Pick:

Qty	Part Number	Description	Batch
2	D2813	Washer	B 29396

7.0	D3562041	STEP ASSEMBLY, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Step Weldment LH

Pick:

Qty	Part Number	Description	Batch
1	D3562-041	Step Weldment LH	B 29411

8.0	D33951	Bushing
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bushing

Pick:

Qty	Part Number	Description	Batch
4	D3395-1	Bushing	B 28455

9.0	AN3C21A	BOLT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
BOLT

Pick:

Qty	Part Number	Description	Batch
2	AN3C21A	Bolt	101189

MF 07-04-02

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-03-31	8	Pick: Qty 2    D2808    spacer    batch: <u>028600</u>	MF	07-03-02				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 31459

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

m100695

11.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

m100433

12.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

m106941

13.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

m100993

14.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

m100680

ME 07-04-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 31459

Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
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15.0	NAS1515H8	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H8	Washer	m101331

16.0	MS210433	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
4	MS21043-3	Nut	m102545

17.0	MS24693C280	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description	Batch
2	MS24693-C280	Screw (or MS24694-C565)	m101390

mf 07-09-02

18.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: m101472

COAT exposed HARDWARE WITH LPS PROCYON .

A/R LPS PROCYON BATCH: m17045

UMF 07-03-02

19.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07/03/02 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

*DRON TIRE DE INFO*

*B29384*

*B29594*

*07/04/03*

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-1

Bushing

*B26565-1*

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-3

Bushing

*B26168-1*

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2810-5

Strut

*B27103-1*

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3396-1

Spacer

*B26771-1*

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Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C6A	Bolt	M100651 ✓

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C10A	Bolt	M100273 ✓

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN4C15A	Bolt	M100447 ✓

28.0

AN44C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN44-C7A	Eyebolt	M19620 ✓

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN5C15A	Bolt	M100229 ✓

*[Handwritten signature]*

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Job Number: 31459

Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
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30.0	NAS1515H4	Washer
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Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)  
Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H4	Washer	M101369 ✓

31.0	NAS1515H5	Washer
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Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)  
Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H5	Washer	M100433 ✓

32.0	MS210434	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	MS21043-4	Nut	M101390 ✓

33.0	MS210435	Nut
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
3	MS21043-5	Nut	M18535 ✓

34.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location:

PPP Rev:

*Draft* *E/P 04/04/03 ①*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PD Date: 01/04/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 31459

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

②

07/04/05

Job Completion



u 07/04/05

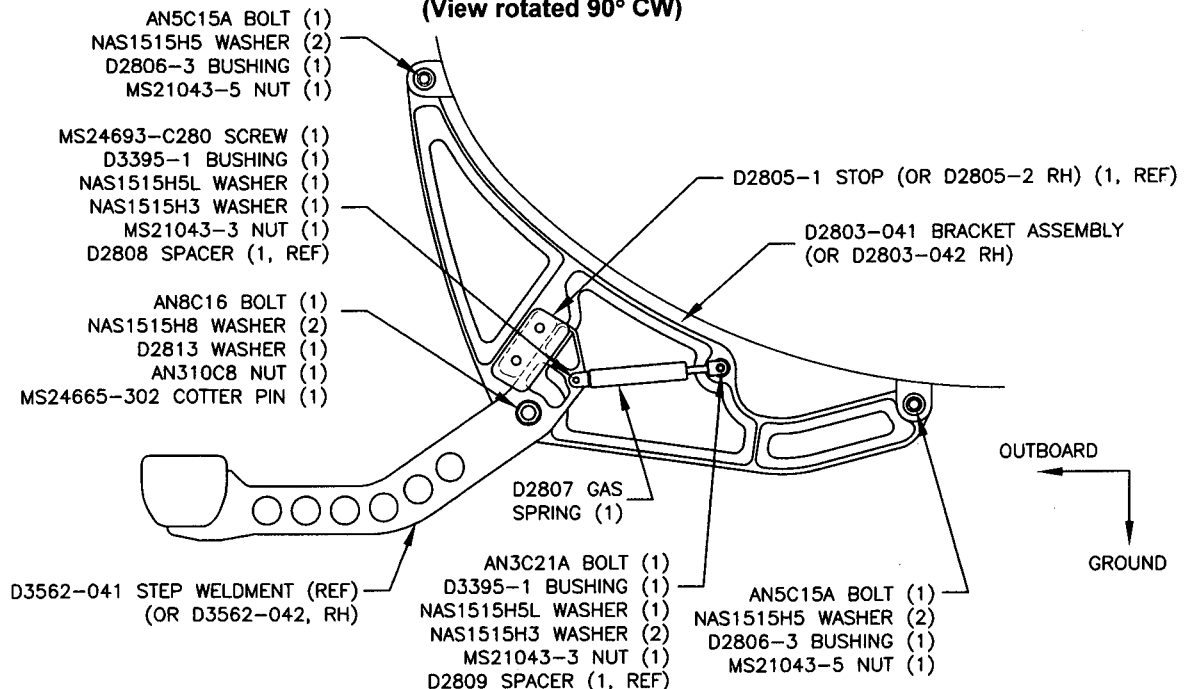
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

**D412-630-033/-034 Heli-Access-Step™ Installation****FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)